

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009647**Date Inspected:** 28-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu yang/ Mr. Xu le feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040775 perform SMAW welding on, Inter connecting corner splice plate, Weld joint no. ESD1-SPSA3-55. ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G(2F)-Repair.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068250 perform SMAW welding on, Spare strut web to flange, Weld joint no. WD1-A 6001-4-11B. ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2212-TC-U5B.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068865 perform FCAW welding on, Doubler plates of Skin A, West tower, Lift 4, Weld joint no. WSD1-FASA4-2 B/E-15. ZPMC CWI Identified as Mr. Peng guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4332-TC-p4-F.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271

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perform FCAW welding on, Inside Esat tower, Lift 4, Fit lug to Skin C Diaphragm, Weld joint no. ESTL3- 4 B/K-69. ZPMC CWI Identified as Mr. An qing ching. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3F-Repair.

### Visual Inspection Testing:

This QA inspector performed Random Visual Inspection (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as East tower, Lift 3, 85.25 mtr., 92.5 mtr. And 95.5 mtr. Diaphragm to skin B/C, Fit lugs. The weld designations reviewed are as follows:

ESTL3- 4 J/K- 47 to 54, 62, 63, 66 to 71 -102.5 mtr. Fit lugs

ESTL3- 4 J/K- 123 to 130, 140 to 147- 105.5 mtr. Fit lugs

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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